

Date: Thursday, 14/08/2008 10:56:46 AM  
User: Jean-Luc Menard

SPLIT

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SEAT RAIL ASSEMBLY  
Job Number : 41238 Estimate Number : 13534  
P.O. Number : Part Number : D3808041  
This Issue : 14/08/2008 S.O. No. : Drawing Number : D3808 PREL Rev. A  
Prsht Rev. : NC Project Number : N/A  
First Issue : 1 / 1 Type : MACHINED PARTS Drawing Revision : PREL Rev. A  
Previous Run : Material :  
Written By : Due Date : 21/08/2008 Qty: 4 Um: Each  
Checked & Approved By :  
Comment : Est Rev: A New Issue 08-07-31 JLM Verified By: DD

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D38081 Seat Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Seat Rail

BATCH: 41117

2.0 D38101 Hand Retractable Spring Plunger



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hand Retractable Spring Plunger

BATCH: 40774

3.0 MS21209C610 Heli Coil, screw locking, red



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heli Coil, screw locking, red

BATCH: M108847

4.0 MS21209C0815 Heli Coil, screw locking, red



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Heli Coil, screw locking, red

BATCH: M108847

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Install Plunger as per Dwg D3808.

2-Install helicoils x5 as per Dwg D3808.

08.08.18  
08.08.18

SEP 11 12 20 1918

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT RAIL ASSEMBLY

Job Number: 41238

Part Number: D3808041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**

*RF 06.06.20*



*(2)*

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



*(2)*

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *5100*

*8/8/20*

*54*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/10/09 RF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*08.08.20*

**POSITIVE RECALL**

**EFFECTIVE**

*08/14*

**AUTH**

*4*

**RELEASED**

*RF*

**DATE**

*06.08.20*

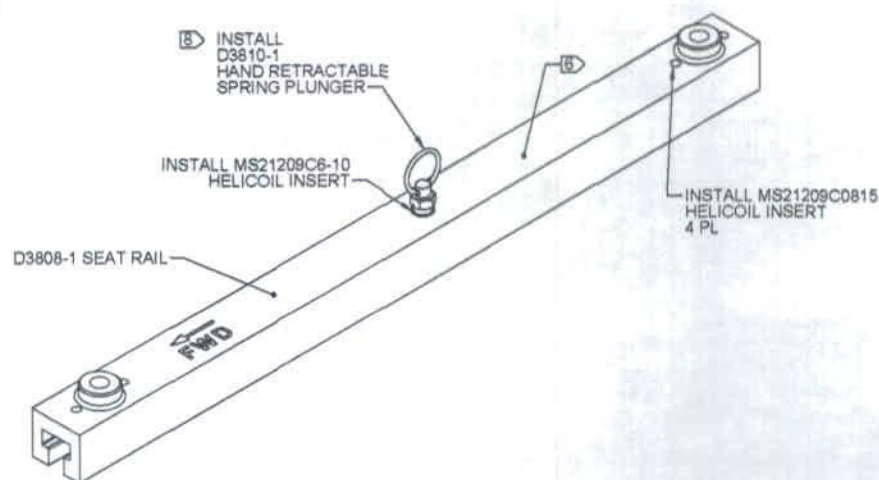
APPROVAL  
ENGINEERING



PRELIMINARY ISSUE  
REV 01.01.20

M108847

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



REFERENCE ONLY

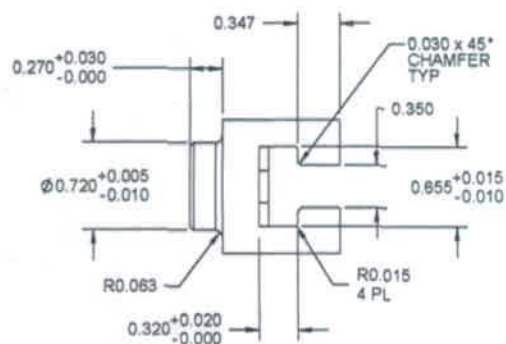
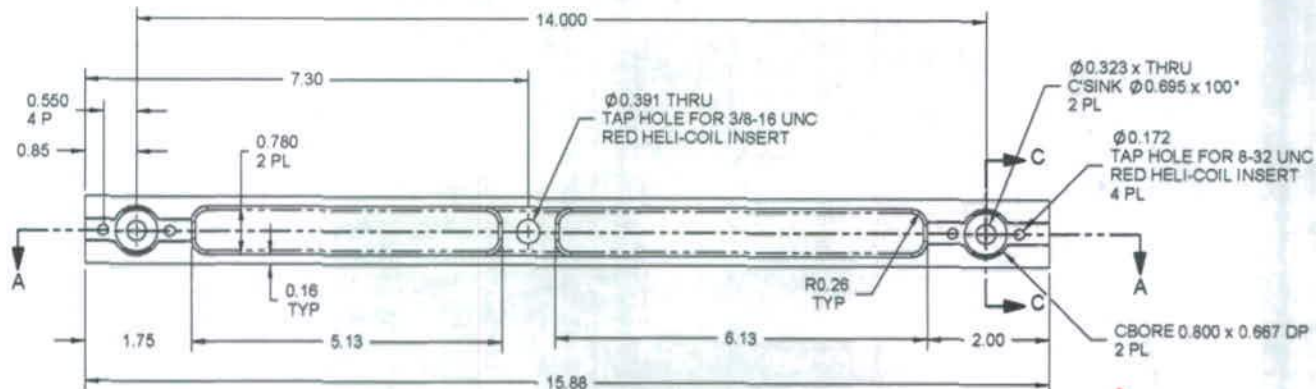
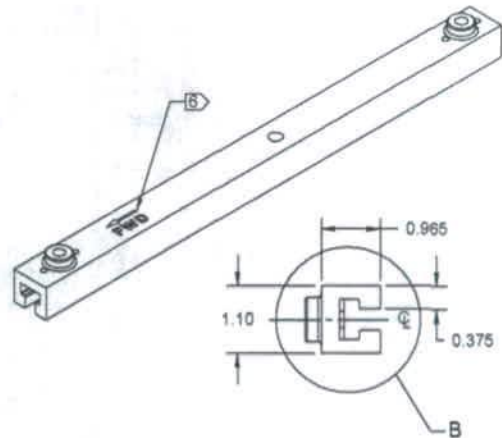
**D3808-041 SEAT RAIL ASSEMBLY**

**D3808-041 NOTES**

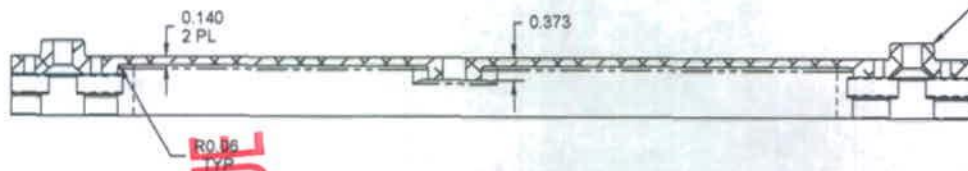
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
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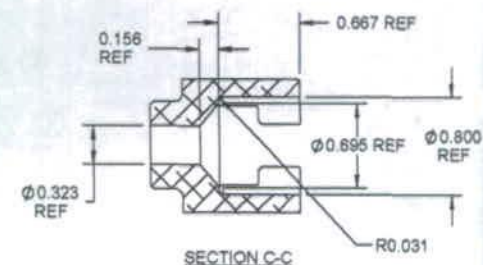




DETAIL VIEW B



SECTION A-A



SECTION C-C

REFERENCE ONLY

PRELIMINARY ISSUE

D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

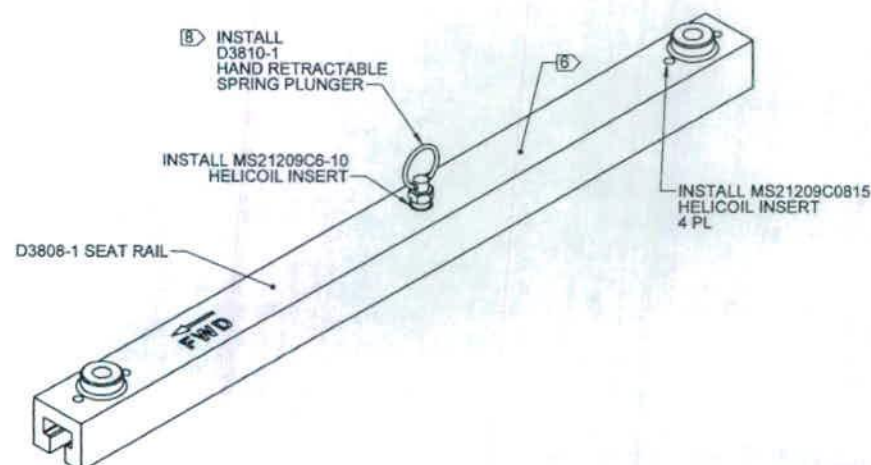
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DRAWN	RF		
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MFG. APPR.		D3808	SHEET 2 OF 2
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DE APPR.		SEAT RAIL ASSEMBLY	NTS
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10221 V. 10.10.10.10

REFERENCE ONLY



QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



**D3808-041 SEAT RAIL ASSEMBLY**

**RELEASED**  
08-09-08

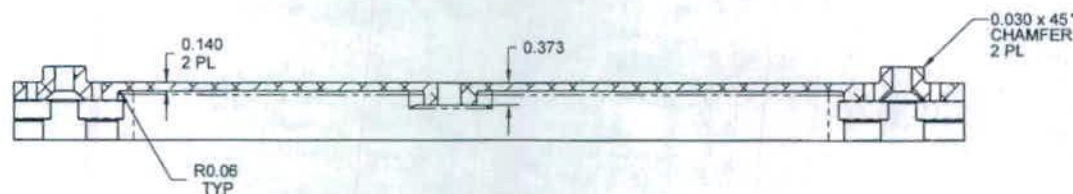
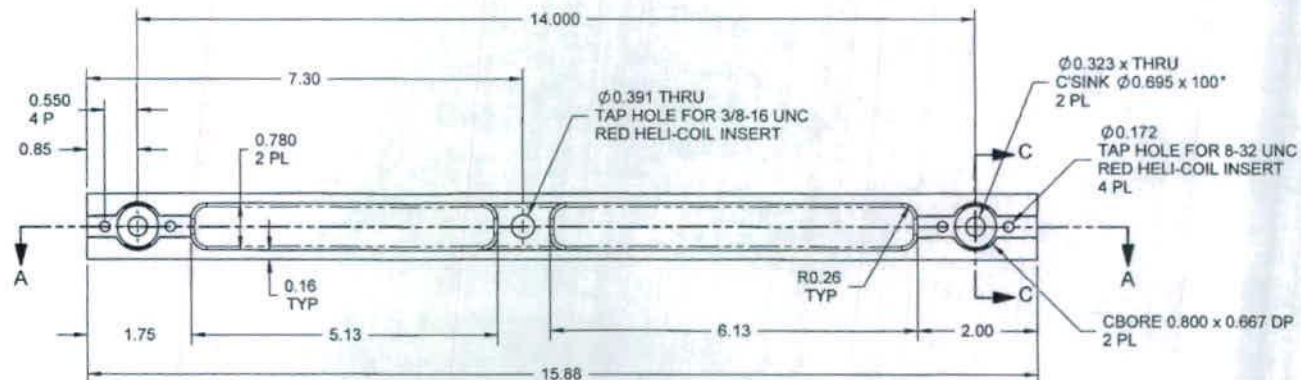
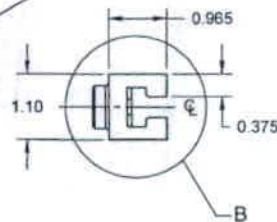
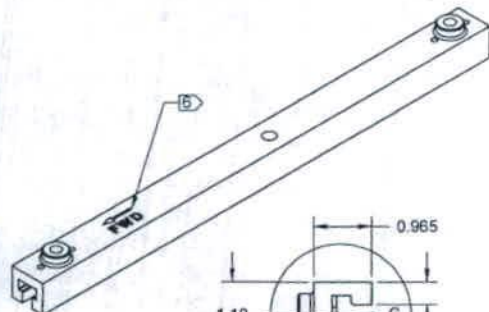
**D3808-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
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A	NEW ISSUE	RF	08.08.08
REV	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 1 OF 2
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DE APPR.		SEAT RAIL ASSEMBLY	NTS
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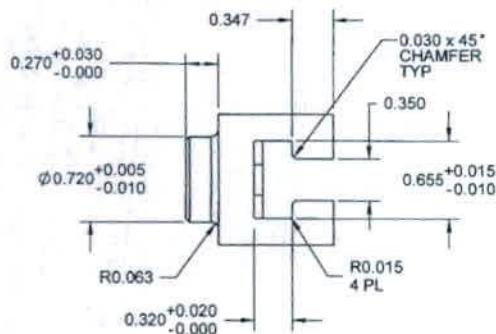
*W/O 41238*



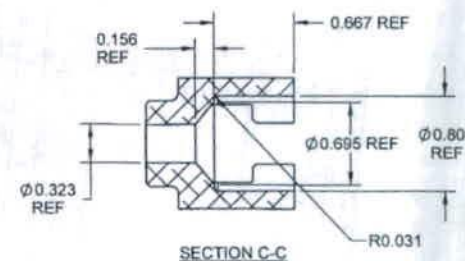


SECTION A-A

D3808-1 SEAT RAIL



DETAIL VIEW B



SECTION C-C

RELEASED

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
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CHECKED			DRAWING NO	REV. A
MFG. APPR.			D3808	SHEET 2 OF 2
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